

Date: Tuesday, 16/09/2008 1:22:19 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 42029
 Estimate Number : 11181
 P.O. Number :
 This Issue : 16/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R & D SM/MED FAB
 Previous Run : 41795
 Part Number : D32941
 Drawing Number : D3294 PROTO
 Project Number : N/A
 Drawing Revision : PROTO
 Material :
 Due Date : 30/09/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : JLD 08.9.16
 Comment : Est A 04.08.24 New issue KJ/JLM
 Est Rev:B Now On Waterjet 07-03-26 JLM
 Est Rev:C 08-07-16 Redesign part DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S080 2024-T3 .080 sheet



Comment: Qty.: 2.1072 sf(s)/Unit Total : 25.2869 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick
 (M2024T3S.080)
 Identify for D3294-1
 Batch: ~~109424~~ x8 = 109424 10-10-02

2.0 WATER JET 109424 x4 FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3294
 Dwg Rev: B
 Prog Rev: B

10-10-02

(12)

2-Deburr if necessary 10-10-02

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

10-10-02 (X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 1:22:20 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42029

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

1/7

08/10/23

Done at 16/09/08
#2-2

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Form as per Dwg D3294

JB 08/10/28 (10)

(PTO)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/28 (X10)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-A 08/10/28

(10X)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 10 5642

(10X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:20
320 OF
7:50

M-A 08/10/31

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FX 08/10/31

(10)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 211

Identify @ Rev B-
when used in 350-567 - CHG # with change

AS 08/10/31

(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3294-1 PAR #: N/A Fault Category: Prod - Sm Med NCR: Yes No DQA: JA Date: 08.11.18
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: JA Date: 08/11/20

NCR: <u>42029</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/28	6	1 piece crack at the bend. first piece at the bend crack was crooked	08.10.28	SCRAP & DESTROY Qty 2 No replace	08/10/28	08.10.28	08.10.28	08.10.28
		first time in production						
		R.C: 1st piece was bent crooked (human error: did not position properly). 2nd piece cracked: cracked on the vent edge of the material (not deburred well enough)						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42029

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-31

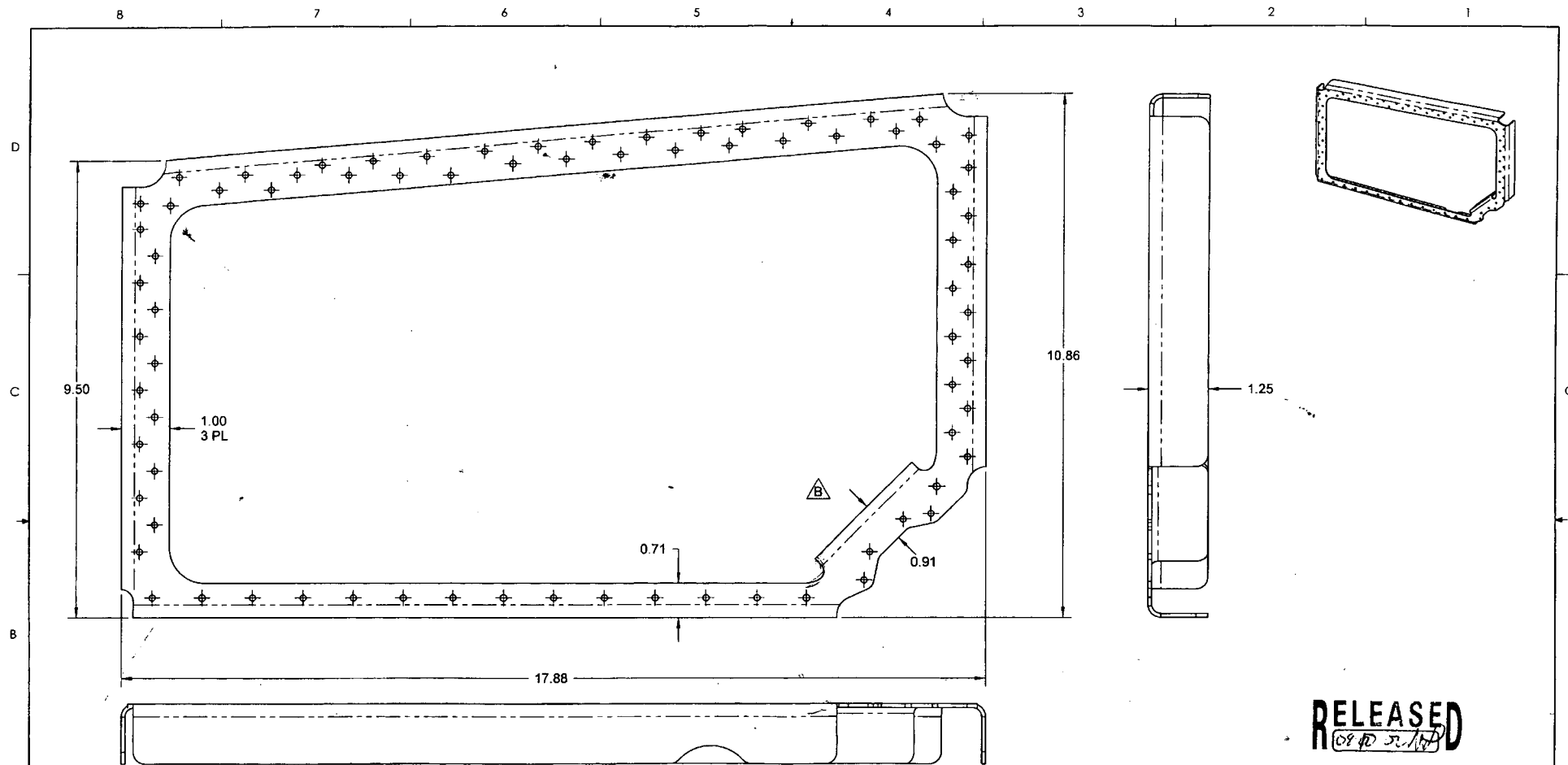
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3294-1 BRACKET
(MADE FROM D3294-1F)

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3294-1 USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.79 lbs
- 8) MACHINE PER DRAWING FILE "D3294-B2.DXF"

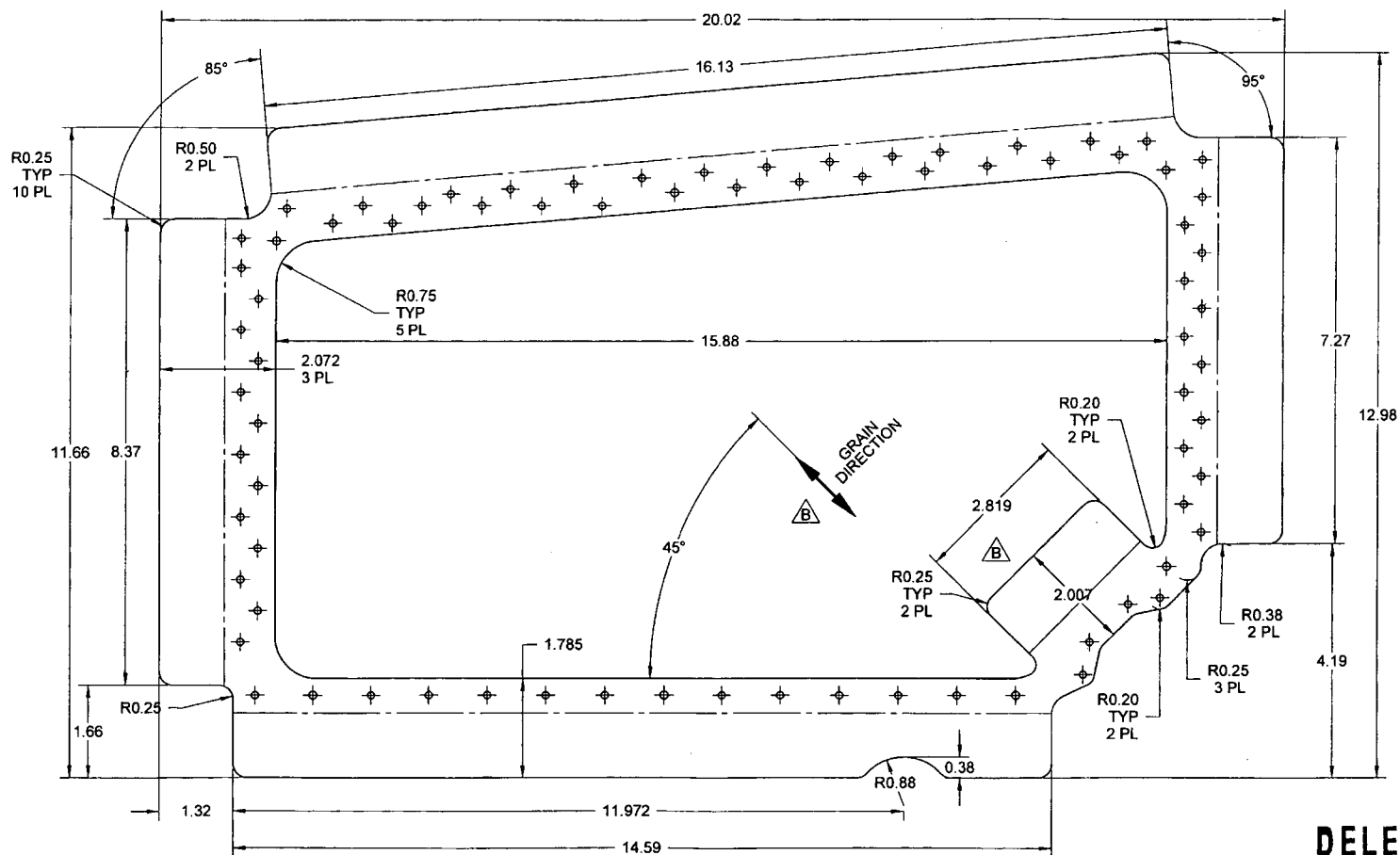
RELEASED
08.09.22

B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	CP	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3294** REV. 8
SHEET 1 OF 3
TITLE **BRACKET** SCALE NTS







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D3294-1F BRACKET FLAT PATTERN

Wb 42029

RELEASED
08-10-02/NT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3294	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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